

Date: Tuesday, 11/13/2007 1:33:50 PM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD  
 Job Number : 35697  
 Estimate Number : 12711  
 P.O. Number :  
 This Issue : 11/13/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 33881  
 Part Number : D35373  
 Drawing Number : D3537 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 11/20/2007 Qty: 60 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A New Issue 07-02-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 063 Sheet



Comment: Qty.: 0.1512 sf(s)/Unit Total : 9.0720 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: 105997 IB 07-11-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3537  
 Dwg Rev: C IB 07-11-15  
 Prog Rev: C

2-Deburr if necessary IB 07-11-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3  
 Form Joggle as per Dwg D3537 on brake using Jig DT8158

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:33:50 PM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35697

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



QSP019



counters

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Staluliz

(x93)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R 2059B Hardcoat

B10615 / B106390

08-08-15

(x38)

Weld hardcoat as per Dwg D3437

8.0

QC10

VISUAL WELDING INSPECTION



08-08-15 (38)



Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



08-08-15 (38)



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



M106442



(38X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-2 08/08/18

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-08-18

(38)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-17

BR 08-08-18

(38)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

Job Completion



MF 08-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35697
Description: Wearpad		Part Number: D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

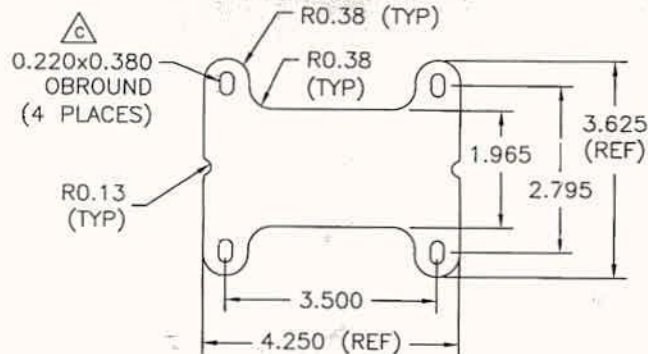
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.865	X			
3.500	+/-0.010	3.503	X			
1.965	+/-0.010	1.964	X			
2.795	+/-0.010	2.799	X			
3.625	+/-0.010	3.625	X			
0.220 x 0.380	+/-0.010	0.22 x 0.381	X			

Measured by: IB	Audited by: [Signature]	Prototype Approval: N/A
Date: 07-11-14	Date: 07-11-15	Date: N/A

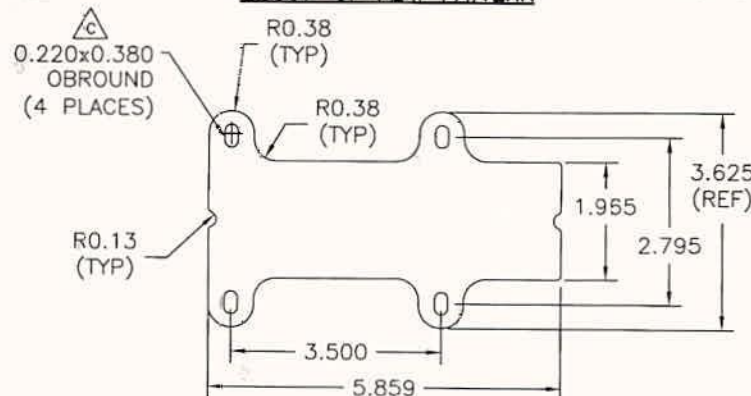
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM [Signature]	[Signature]



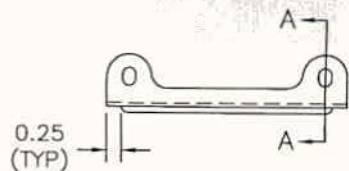
### D3537-1F FLAT PATTERN



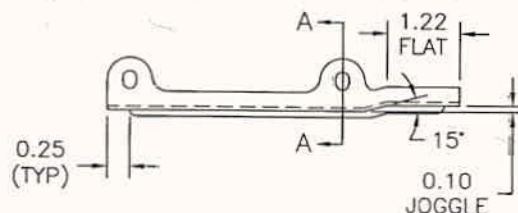
### D3537-3F FLAT PATTERN



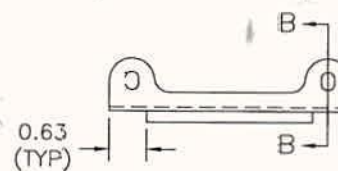
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



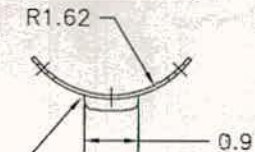
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

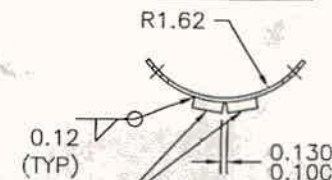
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

### SECTION A-A



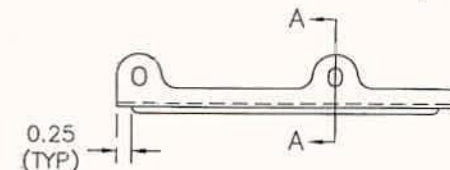
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

### SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



**RELEASED**  
07.05.03 PM  
per ECU  
962

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	05.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
DART AEROSPACE USA, INC.	PORT HADLOCK, MA	SHEET 1 OF 1
		SCALE 1:2

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